Work Orde		899												Page	: 1
Revision ID: Item Name:	D412-709-01 Escape Panel N	Modification			Accept						Setup	Start Stop			
Start Date: Required Date: Reference:	4/20/10 4/27/10	Start Qty: 2.00 Req'd Qty: 2.00					ist Item l istomer:	ID:				C44	1 (20)((6) 8	B118 181 1181 188	ı
Approvals:	Process Pla	n: <u>C</u> L	Date:	10/4/20	Tooling: SPC (Y/N):			ate:		-	Run	Start Stop			, -
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hours		Draw Number	Draw Rev.	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr													
IIN-D412-709	Rev	С						120100							
DC Document Control		DOCUMENT CONTRO Memo Photocopy		ype labels per PPI	0.00 0.00 PD412-709-011 CHG	g0001 2	ialis	1.5	,	K) da	r Cl	- 10	105/17		h
110 Packaging		Pick Kit Memo			0.00						0-3	5- [(<u> </u>	2/1	
Packaging 120 OC		QC4- 100% Inspect kits	for comple	teness	0.00	o www.	8			(+2))				_

Quality Control

w/o: 5	7899	WORK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
(0)5/18	块 100	D3561-1 B2 5000 at +1 parkit - Sicksliera	sl	10-5-10	غ		Solorlis
		up Drte who + Born. ADD coly of new Born for Nelsoare		10.05.20			Siolodis

	11/0	DIC CORED MAN COMPONIA	105 (1105)	
Re	esolution:	Disposition:	QA: N/C Closed:	Date:
Part No: D412	2-709-011 PAR #:	Fault Category:	NCR: Yes No DQA:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	A I	A					
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Chief Eng Date			Section C	Approval Chief Eng	Approval QC Inspector				
			-					-				
· <u></u>] .		1					ľ				

Work Order ID 57899

April 20, 2010 7:05:29 AM



Page 2

Item ID:

D412-709-011

Accept

Setup Start

Stop



Revision ID:

Item Name:

Escape Panel Modification

Start Date:

Required Date: 4/27/10

4/20/10

Start Qty: 2.00

Req'd Qty: 2.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

SPC (Y/N):

Set Up/

Run Hours

Date:

lev A

Date:

Draw

Rev.

Plan

Code

Run Start

Reject

Qty

Insp.

Stamp

Stop

Reject

Number

Sequence ID/

Work Center ID

Packaging Packaging

Operation Description

Packaging

0.00 Memo

Date:

Identify and pack for shipping as per PPP D412-709-011

Location:

140

130

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

Accept

Qty

10/05/19 197 mf 10-5-19

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CH	ANGE	By Date Qty				Approval Chief Eng / Prod Mgr	Approval QC Inspector
	•								i	
										·
Part No	e e	PAR #:	Fault Cat	edory.	NCR	· Vas N	lo DOA		Data	
		esolution:								
NCR:		V	VORK OR	DER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	ction B	Sign &	Verific: Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date	Section	-	Office Eng	CO ITISPECTOI
										-
	ļ									
				•						
						,				
					I .		1			

Picklist Print April 20, 2010 7:05	:28 AM											Page 1
Work Order ID: 57	899 12-709-011 Escape Panel Modif IPP Rev:B Remov			11-06 JLM .11.12 EC					tart Date: 4/2 Start Qty: 2.0		Required Da	
Component Item ID/ Item Name AN6-20A	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 120	Unit of Measure Each	Qty on Hand 49.0000	Remaining Qty To Pick 6.0000	Qty Sued	Pate squed	Status
AN960JD101; \2	- HI 1101 HIII BIIIN DI 1101	Purchased	No	Warchou Loca Main War ST34	tion rehouse	<u>Loc C</u>	49 49 Each	Loc Code 4,551.000	4.0000	6-5-1	85	Ç
AN960JD616: / 1/3/)/	1900663 . 	Purchased	No	Warehou Loca Main War ST34	tion rehouse		551 551 Each	Loc Code 49.0000	10.0000	\$ M113	3524	10-5-180
Washer				Warehou Locai Main Wai S734	tion rehouse	<u>Loc C</u>	4 9 49	<u>Loc Code</u>	-	10	-	(21)

W/O:			W	ORK ORDER CHANG	GES				· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	OCEDURE CH	ANGE	E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	
				•						
Dark Na								<u> </u>		
Part No		PAR #:								
	Re	esolution:							Date:	
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (I	NCR)				
DATE	STEP	Description of NC	In Mala I		tion B		Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	on C	Chief Eng	QC Inspector
							\-			-

April 20, 2010 7:05:28 AM

Work Order ID: 57899

Parent Item:

D412-709-011

Parent Item Name:

Component Item ID/

Escape Panel Modification

Comments:

Washer

D3118-3

IPP Rev:B Removed Manufacturing

IPP rev C removed sub-components

Start Date: 4/20/10

Required Date: 4/27/10

Start Oty: 2.00

Required Qty: 2.00

Item Name AN960JD616L

Replacement Mfg/ Item ID

Purch Purchased Bin Primary Item Location No

07.11.12

05-11-06 JLM

EC

Last Location

Route Seq ID 120

120

Unit of Measure Each

Oty on Hand 135.0000

Remaining Qty To Pick 10.0000

Date Issued*

Status

Warehouse Location

ST34 111819 Loc Qty

Loc Code

Main Warehouse

135 135 Each

9.0000

Qty

Issued

Sign Assembly

Manufactured

Manufactured

No

No

Warehouse Location Loc Qty

Loc Code

Main Warehouse

ST037

120

9 Each

4.0000

2.0000

Window Assembly

Warehouse Location Loc Qty

Loc Code

Main Warehouse

ST216

W/O:			V	VORK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CH	IANGE	Ву		Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	es No	DQA:	Date: _	
-	R	esolution:	Disposit	ion:	QA: N/C	Clos	ed:	Date: <u>-</u>	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (N	CR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section		0	Verification	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sig Da		Section C	Chief Eng	QC Inspector
									-
					:				
-									
<u> </u>	<u> </u>					- 1	•		

Picklist Print

April 20, 2010 7:05:29 AM

Page 3

Work Order ID: 57899

Parent Item:

D412-709-011

Parent Item Name:

Escape Panel Modification

Comments:

IPP Rev:B Removed Manufacturing

IPP rev C removed sub-components

05-11-06 JLM 07.11.12 EC

Start Date: 4/20/10

Required Date: 4/27/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name

D3224-1

Replacement Item ID

Mfg/ Purch Manufactured

Manufactured

Primary Bin Item Location No

No

Last Location Route Seq ID 120

Unit of Measure Each

Qty on Hand 3.0000

Loc Code

Loc Code

Remaining Qty Qty To Pick 2.0000

Issued

Date Issued

10-5-185

\$tatus

Frame

Warehouse Location

Main Warehouse

ST218 36312

120

Loc Qty

3 3

11

135.0000 16.3320

D3237-1

Seal Retainer

(D3237-1-0980) cut (1) at 98.00" as per dwg ***per kit***

Warehouse Loc Qty Location Main Warehouse ST414A 135 124

W/O:			V	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	IANGE	Ву		Date C	ity	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	<u> </u>									
Part No		PAR #:								
	R	esolution:							Date:	
NCR:	\	V	VORK OR	DER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description		ın &	Verificati		Approval	Approval
		Georgia	Chief Eng	Chief Eng		ate	Section C	,	Chief Eng	QC Inspector
										<u> </u>

Picklist Print

April 20, 2010 7:05:29 AM

Page 4

Work Order ID: 57899

D412-709-011

Parent Item Name:

Escape Panel Modification

Comments:

Parent Item:

IPP Rev:B Removed Manufacturing

IPP rev C removed sub-components

Start Date: 4/20/10

Start Qty: 2.00

Required Date: 4/27/10

Required Qty: 2.00

Component Item ID/ Item Name

Item ID

Replacement Mfg/ Purch

Bin Item Manufactured No

Primary Location

05-11-06 JLM

07.11.12 EC

Last Location Route Seq ID 120

Unit of Measure

Remaining Qty on Hand 56.0000 16.3320

Qty Qty To Pick Issued Date Issued

10 -5-180

Status

D3237-3

Seal Filler

(D3237-3-0980) cut (1) at 98.00" as per dwg ***per

kit***

: 42 D3239-1

Manufactured

Purchased

No

No

Loc Qty Loc Code Warehouse Location

120

Main Warehouse



Each

19.0000

Loc Code

Loc Code



10-5-18

Warehouse Location

Main Warehouse



19 19 120 Each

Loc Qty

1.129.000 4.0000

Loc Qty Warehouse Location

Main Warehouse ST300

1129

145 984

Dart Aerospace Lt	d
-------------------	---

W/O:		4	W	ORK ORDER CHANGI	ES	10			
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Dort No.						· · · · · · · · · · · · · · · · · · ·			
Part No		PAR #: olution:							
NCR:				ER NON-CONFORMA					, et
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign &	Verific Secti		Approval Chief Eng	Approval QC Inspector
		-	Chief Eng	Chief Eng	Date			_	-

Picklist Print

April 20, 2010 7:05:29 AM

Page 5

Work Order ID: 57899

Parent Item:

D412-709-011

Parent Item Name:

Escape Panel Modification

Comments:

IPP Rev:B Removed Manufacturing

IPP rev C removed sub-components

05-11-06 JLM 07.11.12 EC Start Date: 4/20/10

Required Date: 4/27/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name

MS21042L6

Replacement Item ID

Mfg/ Purch Purchased

Purchased

Primary Bin Item Location No

No

Last Location Route Seq ID 120

Unit of Measure Each

Oty on Hand

Remaining 245.0000 6.0000

Qty To Pick

Qty Issued

Date Issued

Status

Warehouse

Loc Qty

0-5-18

Loc Code

28.0000

Location

Main Warehouse

ST300 111578

245 245 120

Each



10-5-18

MS35207-262

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST295 109840 28 28

Dart Aerospace L	.td
------------------	-----

W/O:			W	ORK ORDER CHANG	ES		78				
DATE	STEP	PRO	OCEDURE CH	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No:		PAR #:	Fault Car	legory:	NCR: Yes No DQA: Date:						
	Re	solution:	Dispositi	on:	_ QA: N/C Clo	QA: N/C Closed: Date:					
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR))		**************************************			
DATE	STEP	Description of NC Section A		Corrective Action Sect		Verification	n Approval	Approval QC Inspector			
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng				
								-			

IIN-D412-709 Page 12 of 12

5.0 FAR SLIST

Qty -01i	G(y 113	Gay -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X	A ALLEGE SPINDS		Armer macrocons				D412-709-011	ESCAPE PANEL MODIFICATION KIT
(1, 1	X			-			D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
1		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
!			Х				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				Х			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					Х		D412-709-021	HINGE PAMEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
ļ							1 50400 0705	Location
		·	1				D2126-0720	LOCKING SEAL
<u> </u>			eray t he ray, — consummana				D3118-3	SIGN ASSEMBLY
} }				1 ·			D3136-041	WINDOW ASSEMBLY
			more than course				D3136-043	WINDOW ASSEMBLY
							D3224-1	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
,				1			D3237-1-0980	' SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
,				1			D3237-3-0980	SEAL FILLER
2							D3239-1 /	COVER
							D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
,				1		1	D3561-1	WINDOW SEAL TOOL
	•						AN6-20A	BOLT
1 2	.						AN960JD10L	WASHER
5							AN960JDT0L	WASHER
		إسب	**********					
5 2 3 2							AN960JD616L	WASHER
							MS21042L3	NUT
							MS21042L6 /	NUT
2							MS35207-262	SCREW
TAGE T	1	:						

	-									
W/O:			V	ORK ORDER CHANG	iES		····		,	•
DATE	STEP	PRO	OCEDURE CH	EDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-		
Part No	•	PAR #·	Fault Ca	togory	NC	P. Voo. I	do DO	<u> </u>	Doto	
1 411 110					NCR: Yes No DQA: Date: QA: N/C Closed: Date:					
		Y						***	Date:	
NCR:	T		WORK OR	DER NON-CONFORMA	ANCE	(NCH				
DATE	STEP	TEP Description of NC Section A	Corrective Action Section B			0:	Verification Approval			Approval
			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
		,								